

5/19

D3233-041

~~B22421A~~

DART AEROSPACE LTD	Work Order:	22987
Description: Wheel Assembly	Part Number:	D3233-041
Dwg: D3233 Rev. B	Qty:	20 9
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>KJ</i>	05.04.13	20
2	MFA	Pick: Qty Part Number Description Batch 2 D3233-7 Shaft Sleeve <i>B22927</i> 2 D3233-9 Tire & Rim Assembly <i>B22421A</i> 2 D3333-5 Hub Sleeve <i>B22926</i> 4 NKI 30/20 Bearing & Inner Sleeve <i>M16867 M17346</i> 8 Shim Stock 0.004" thick Brass Shim Stock <i>M17235</i> 4 35x45x7 Axel Seal <i>M17346</i> or CR 35x45x7 HMS4 R			
3	MFA	Press out bearings that are supplied with D3233-9 wheel and discard them.	CPL	05.05.04	9
4	MFA	Cut shims and assemble as per Dwg D3233	CPL	05.05.04	9
5	MFA	Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.	CPL	05.05.04	9
6	QC5	Inspect work to Step 5	<i>J</i>	05.05.05	9
7	ST	Identify and Stock	CPL	05.05.05	9
8	AC	Cost / part: <u>358.32</u>	SAC	05.05.20	9
9	DC	Close W/O <u>271.65</u> Inspect Level 21	<i>KJ</i>	05.05.24	9

Rev	Date	Change	Revised By	Approved
A	05.01.12	New issue	KJ/JLM	<i>J</i>
B	05.03.03	Made in house	KJ/JLM	<i>J</i>

RELEASED  
*05.03.15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

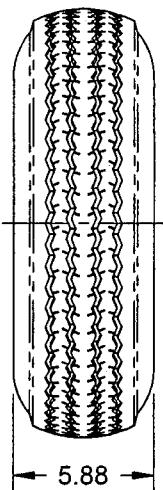
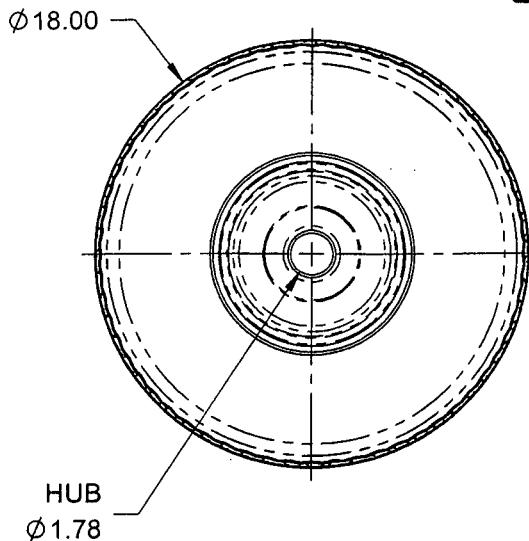
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

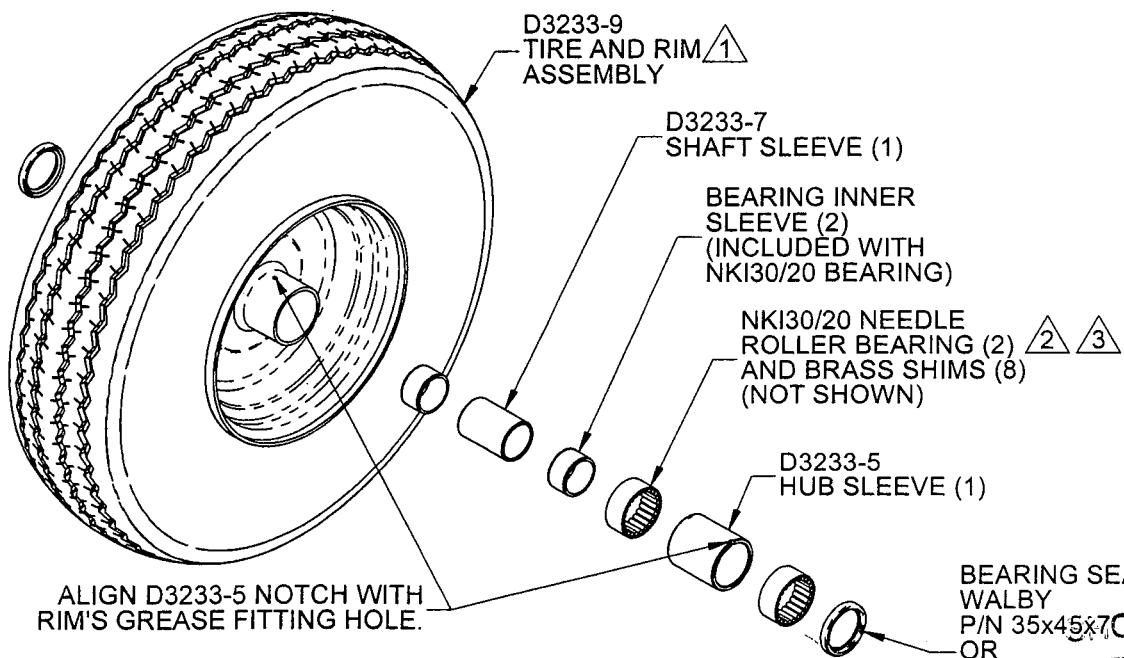
# PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	DRAWING NO.	D3233	REV. B	
DATE	05.03.08	TITLE	WHEEL ASSEMBLY	SHEET 1 OF 3	
A	05.02.18	SCALE			
B	05.03.08	1:1			



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



## D3233-041 WHEEL ASSEMBLY

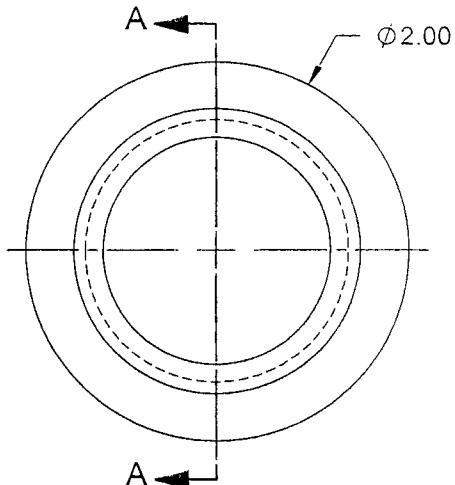
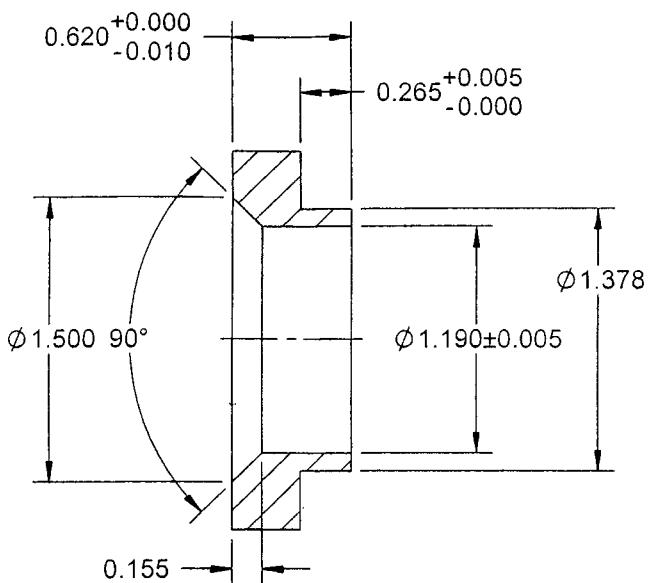
### NOTES:

- 1) POSSIBLE SUPPLIER: McMaster-Carr, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY  
RETURN TO  
CR 35x45x7-HMS4 R  
P/N 13927-ENGINEERING  
(2 PLACES)  
UNCONTROLLED COPY  
SPECIAL EDITION  
NOTICE  
ORDER  
NO. 22987

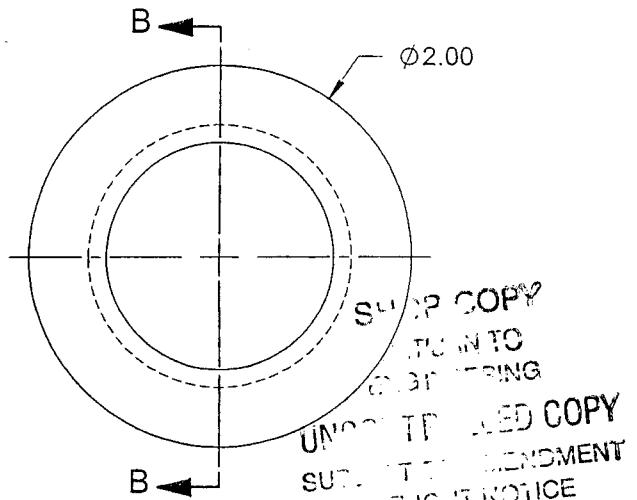
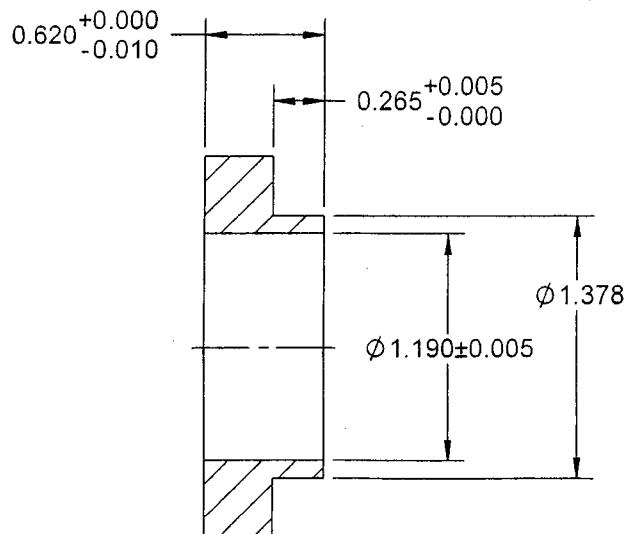
# PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1



SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER

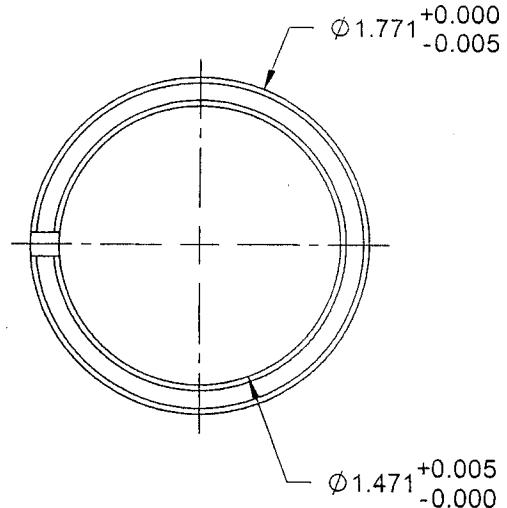
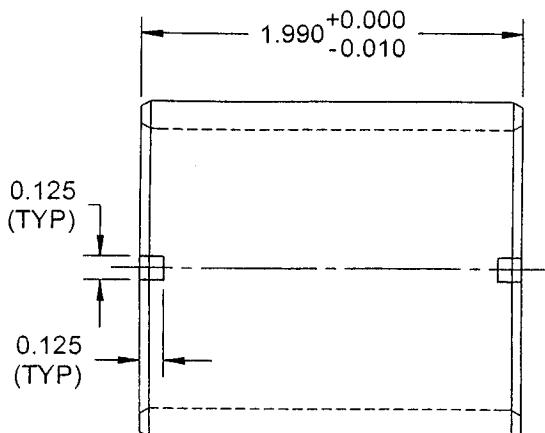
WORK ORDER  
NO. 22987

NOTES:

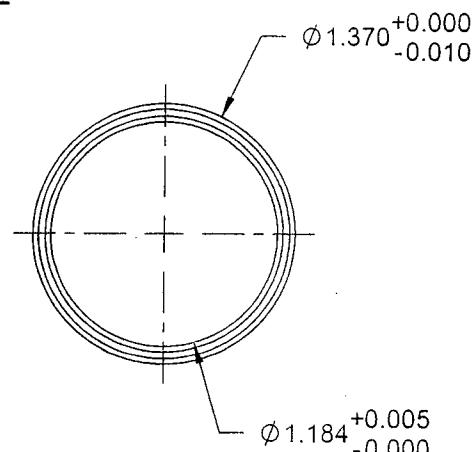
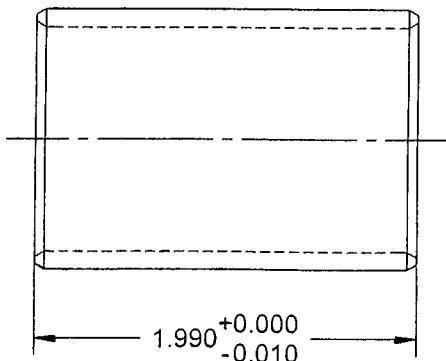
- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

# PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513<sup>T-00</sup> MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS NOTICE (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

WORK ORDER  
NO. 22987

U<sup>1</sup> F<sup>1</sup> C<sup>1</sup> COPY

DOCUMENT

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2005  
02:25 pm

Work Order No : 0022987  
 Project Name : D3233-041  
 Project For : WK519  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3233-041  
 Description : Wheel Assembly  
 Manufactured : Yes  
 Amount Req'd : 20  
 Amount Done : 0  
 Start Date : 04-11-05  
 Est Finish Date : 05-07-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	5.00	100.00		
Production Cost	0.00	80.35	100.00	0.00	80.35
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	80.35	100.00		
Mark up	0.000	0.000			
Selling Cost	0.00	80.35			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	( -80.35)